
वस्त्रादि — मोमयुक्त सूती गोटे
के फीते — विशिष्टि

(पहला पुनरीक्षण)

**Textiles — Waxed Cotton Selvedge
Tapes — Specification**

(*First Revision*)

ICS 59.080.30

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भारतीय मानक ब्यूरो
BUREAU OF INDIAN STANDARDS
मानक भवन, 9 बहादुरशाह ज़फर मार्ग, नई दिल्ली – 110002
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI-110002
www.bis.gov.in www.standardsbis.in

FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by Technical Textiles for Clothtech Applications including Narrow Fabrics and Braids Sectional Committee had been approved by the Textile Division Council.

This standard was first published in 1972 and has been revised now to align it with latest trade practices. The sampling plan has also been harmonized with other standards on similar products.

The composition of the Committee responsible for the formulation of this standard is given in Annex B.

For the purpose of deciding whether a particular requirement of this standard is complied with the final value, observed or calculated expressing the result of a test or analysis shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

TEXTILES — WAXED COTTON SELVEDGE TAPES — SPECIFICATION

(First Revision)

1 SCOPE

This standard prescribes the requirements of grey, waxed cotton selvedge tapes used in electrical components of automobiles.

2 REFERENCES

The standards listed in Annex A contain provisions, which through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards.

3 MANUFACTURE AND WORKMANSHIP

The tape shall be uniformly woven from yarn having a nominal count of 15 tex \times 2 (40s/2) in warp and 20 tex (30s) in weft with regular and firm selvages. The tapes shall be given a waxed finish using paraffin wax adding not less than 22 percent and not more than 24 percent by weight.

4 REQUIREMENTS

4.1 The tapes conforming to this standard shall also meet the requirements given in Table 1.

4.2 Unless otherwise stated, 5 percent of the tapes may be effected in a maximum of two pieces. Each such length shall not be less than 5 metres.

5 PACKING

The tapes shall be packed in rolls in such a way that the edges are not folded over. The rolls shall be individually packed as per contract.

6 MARKING

6.1 Each roll of tapes shall be legibly marked with the following information:

- Name of the material and variety no.;
- Width (mm);
- Length of roll (m);
- Lot/Batch no.;
- Indication of the source of manufacture; and
- Month and year of manufacture.

6.2 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the product(s) may be marked with the Standard Mark.

7 SAMPLING

7.1 The lot shall consist of all the waxed cotton selvedge tapes of same variety and delivered to a buyer against one despatch note.

Table 1 Requirements of Waxed Cotton Selvedge Tape

(Clause 4.1)

	Width, mm	Length, m	Fold of Yarn		Ends in Full Width, <i>Min</i>	Picks per dm, <i>Min</i>	Thickness, mm, <i>Max</i>	Weight per 100 m, g, <i>Max</i> (Unwaxed)	Breaking Load on Full Width \times 20 cm Test Length, kgf, <i>Min</i>
			Warp	Weft					
	(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
	12.5 \pm 1	60 or as agreed	2	1	40	138	0.3	153	13.5
Method of Test	----- IS 1954 -----		—	—	----- IS 1963 -----		IS 7702	IS 1964	IS 1969 (Part 1)

7.2 Unless otherwise sampling plan is specified in the contract or order, the sampling plan as given in Table 2 may be used for inspecting and testing of tapes against this standard. The number of rolls to be selected from the lot for assessing manufacture and workmanship (*see 3*) and testing length, width, ends, picks and thickness and weight shall be as per col 2 of Table 2. The number of test specimens to be selected for other tests shall be in accordance with col 4 of Table 2.

To ensure the randomness of selection, IS 4905 may be followed.

7.3 Criteria for Conformity

The lot shall be declared conforming to the requirements of this standard if the total number of defective samples does not exceed the permissible numbers given in col 3 or col 5 of Table 2 as applicable.

Table 2 Sampling Plan for Waxed Cotton Selvedge Tape

(*Clauses 7.2 and 7.3*)

Lot Size	Sample Size	Permissible No. of Defectives Samples	Sub-sample Size (to be drawn from sample)	Permissible No. of Defectives Sub-Samples
(1)	(2)	(3)	(4)	(5)
2 to 25	3	0	3	0
26 to 90	13	1	3	0
91 to 150	20	2	13	1
151 to 280	32	3	13	1
281 to 500	50	5	20	1
501 to 1200	80	7	32	2
1201 and above	125	10	50	3

NOTE — If sample size equals or exceeds lot size, carry out 100 percent inspection.

ANNEX A

(Clause 2)

LIST OF REFERRED INDIAN STANDARDS

<i>IS No</i>	<i>Title</i>	<i>IS No</i>	<i>Title</i>
1954 : 1990	Determination of length and width of woven fabrics — Methods (<i>second revision</i>)	1969 (Part 1) : 2018/ ISO 13934-1 : 2013	Textiles — Tensile properties of fabrics: Part 1 Determination of maximum force and elongation at maximum force using the strip method (<i>fourth revision</i>)
1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)		
1964 : 2001	Textiles — Methods for determination of mass per unit length and mass per unit area of fabrics (<i>second revision</i>)	7702 : 2012/ ISO 5084 : 1996	Textiles — Determination of thickness of textiles and textile products (<i>first revision</i>)

ANNEX B*(Foreword)***COMMITTEE COMPOSITION**

Technical Textiles for Clothtech Applications including
Narrow Fabrics and Braids Sectional Committee, TXD 39

<i>Organization</i>	<i>Representative(s)</i>
Senior Quality Assurance Establishment Directorate General of Quality Assurance Ministry of Defence	SHRI A. CHOWDHURY (Chairman)
Defence Materials and Stores Research and Development Establishment, Kanpur	SHRI A. K. YADAV MS PRIYANKA KATIYAR (<i>Alternate</i>)
Federation of Indian Chambers of Commerce and Industry, New Delhi	SHRI ANU HANDA
ICAR-Central Institute for Research on Cotton Technology, Mumbai	DR P. JAGAJANANTHA DR T. SENTHILKUMAR (<i>Alternate</i>)
Indian Institute of Technology, Delhi	PROF AMIT RAWAL PROF BIPIN KUMAR (<i>Alternate</i>)
Indian Technical Textile Association, Mumbai	DR ANUP RAKSHIT SHRI VIKRAM JAIN (<i>Alternate</i>)
JCT Limited, Phagwara	SHRI KHUSHWINDER SINGH SHRI ARWINDER SINGH (<i>Alternate</i>)
M K U Limited, Kanpur	SHRI SUMIT KHANDELWAL SHRI RAJIB PAL (<i>Alternate</i>)
Motilal Dulichand Pvt Ltd, Kanpur	SHRI SHAILENDRA NATH MISRA SHRI SUDHIR SHIVHARE (<i>Alternate</i>)
National Textile Corporation, New Delhi	SHRI R. K. YADAV
Ordnance Parachute Factory, Kanpur	SHRI V. M. BAGADE SHRI S. KONDAIAH (<i>Alternate</i>)
Planet Analysis Pvt Ltd, Kanpur	SHRI PRASHANTA BISWAS
SGS Limited, Gurugram	SMT ANITHA JEYARAJ SHRI GAURAV SARSWAT (<i>Alternate</i>)
Shipra International, Kanpur	SHRI ABHISHEK KUMAR AGRAWAL
S L Banthia Textiles Industries Pvt Ltd	SHRI SANTOSH KUMAR BANTHIA
Sky Industries Ltd, Navi Mumbai	SHRI KAPIL MEHROTRA SHRI MICHAEL (<i>Alternate</i>)
Testtex India Laboratories Pvt Ltd, Mumbai	SHRIMATI MEETA SHIGALA SHRI CHANDRAKANT (<i>Alternate</i>)
Textiles Committee, New Delhi	SHRI R. CHANDRAN SHRI GANESH P. BANGAR (<i>Alternate</i>)
Thanawala and Co, Mumbai	SHRI HEMAL THANAWALA SHRI UPENDRA THANAWALA (<i>Alternate</i>)
The Bombay Textile Research Association, Mumbai	SHRI SHAIKH RIYAZ AHMED DR PRASANTA KUMAR PANDA (<i>Alternate</i>)

<i>Organization</i>	<i>Representative(s)</i>
The Office of Textile Commissioner, Mumbai	SHRI V. K. KOHLI SHRI HUMAYUN K. (<i>Alternate</i>)
The Synthetic and Art Silk Mills Research Association, Mumbai	SHRI SANJAY SAINI SHRI PREMNATH SURWASE (<i>Alternate</i>)
Universal Yarn & Tex Pvt Ltd, Kanpur	SHRI RAJIV K. BHARTIYA
BIS Director General	SHRI A. K. BERA SCIENTIST 'F' AND HEAD (TXD) [REPRESENTING DIRECTOR GENERAL (<i>Ex-officio</i>)]

Member Secretary

SHRI A. K. BERA
SCIENTIST 'F' AND HEAD (TEXTILES), BIS

Bureau of Indian Standards

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Amendments Issued Since Publication

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BUREAU OF INDIAN STANDARDS

Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002
Telephones: 2323 0131, 2323 3375, 2323 9402

Website: www.bis.gov.in

Regional Offices:

Telephones

Central	: Manak Bhavan, 9 Bahadur Shah Zafar Marg NEW DELHI 110002	{ 2323 7617 2323 3841
Eastern	: 1/14 C.I.T. Scheme VII M, V.I.P. Road, Kankurgachi KOLKATA 700054	{ 2337 8499, 2337 8561 2337 8626, 2337 9120
Northern	: Plot No. 4-A, Sector 27-B, Madhya Marg CHANDIGARH 160019	{ 265 0206 265 0290
Southern	: C.I.T. Campus, IV Cross Road, CHENNAI 600113	{ 2254 1216, 2254 1442 2254 2519, 2254 2315
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